

Date: Monday, 28/04/2008 3:54:22 PM
 User: Julie Lecocq

Process Sheet

*SLIP 08/08/08
SP*

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: PEDAL ASSEMBLY	
Job Number	: 38858 -1				Part Number	: D412704041	
Estimate Number	: 11005				Drawing Number	: D412-704-041 REV A	
P.O. Number	:				Project Number	: N/A	
This Issue	: 28/04/2008 S.O. No. :				Drawing Revision	: A	
Prsht Rev.	: NC				Material	:	
First Issue	: 28/04/2008 Type : SMALL /MED FAB				Due Date	: 15/05/2008	
Previous Run	: 38186				Qty:	/ Um: Each	
Written By	:					3	
Checked & Approved By	: <u>JLQ 08.4.29</u>					/ Um: Each	
Comment	: Est Rev:B 05.01.28 Removed hardware on Step 2; Added Figures 1-3 KJ/RF						
	Est Rev:C 06.03.08 Re-format EC						
	Est Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20						
	JLM						
	Est Rev:E 07.05.02 Reformat EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D3204041	Release Pedal Assembly		
Comment:	Qty.: 1.0000 Each(s)/Unit	Total : 4.0000 Each(s)		
Pick:				
Qty	Part number	Description	batch	
1	D3204-041	Pedal Assembly	<u>B38189</u>	<i>28/08/08/06 (3x)</i>
2.0	D32051	Pedal Bracket		
Comment:	Qty.: 1.0000 Each(s)/Unit	Total : 4.0000 Each(s)		
Pick:				
Qty	Part number	Description	batch	
1	D3205-1	Bracket	<u>33854</u>	<i>8/4/08 (4)</i>
3.0	D32053	Back Plate		
Comment:	Qty.: 1.0000 Each(s)/Unit	Total : 4.0000 Each(s)		
Pick:				
Qty	Part number	Description	batch	
1	D3205-3	GHW Bracket	<u>35269</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 3:54:23 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 38858

Part Number: D412704041

Job Number:



Seq. #:	Machine Or Operation:	Description :
4.0	D32061	Pedal Arm
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part number Description batch 1 D3206-1 Pedal arm <u>36835</u>
5.0	D3209041	Bracket Assembly
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part number Description batch 1 D3209-041 Bracket <u>38190</u>
6.0	AN310A	Bolt
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part number Description batch 1 AN3-10A Bolt <u>17566</u>
7.0	AN3154R	Nut
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part number Description batch 1 AN315-4R Nut <u>M17566</u>
8.0	AN410A	Bolt
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part number Description batch 1 AN4-10A Bolt <u>M105442</u> P 84/bs (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 3:54:23 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: PEDAL ASSEMBLY
Job Number: 38858		Part Number: D412704041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
9.0	AN412A	Bolt
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)		
Pick: Qty Part number Description batch 2 AN4-12A Bolt M105143		
10.0	AN413A	Bolt
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick: Qty Part number Description batch 1 AN4-13A Bolt M107321		
11.0	AN960JD10	Washer
Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)		
Pick: Qty Part number Description batch 5 AN960JD10 Washer M107715		
12.0	AN960JD416	Washer
Comment: Qty.: 11.0000 Each(s)/Unit Total : 44.0000 Each(s)		
Pick: Qty Part number Description batch 11 AN960JD416 Washer M107321		
13.0	AN960JD416L	Washer
Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)		
Pick: Qty Part number Description batch 3 AN960JD416L Washer M107008		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 3:54:23 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 38858

Part Number: D412704041

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0 MS21042L3 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description
1 MS21042L3 Nut

batch

M10 X 43

15.0 MS21042L4 Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part number Description
5 MS21042L4 Nut

batch

M10 6051

16.0 MS24694S102 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description
1 MS24694S102 Screw

batch

M14 609

17.0 MS951910 Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description
1 MS9519-10 Bolt

batch

M100290

18.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble pedal as per Dwg D412-704-041

Tighten & Torque Bolts as per Dwg D412-704-041

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 3:54:23 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 38858

Part Number: D412704041

Job Number:



Seq. #: Machine Or Operation:

Description :

19.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part number	Description
4	AN960JD10L	Washer

batch

16612 2X M10YFF5 10X

22.0 AN36A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part number	Description
2	AN3-6A	Bolt

batch

M106662

23.0 MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch: M107665

R8/7 ③

24.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

25.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST195 1X PPP383302X

R8/6 ③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 3:54:23 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 38858

Part Number: D412704041

Job Number:



Seq. #: Machine Or Operation:

Description :

26.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JD 08/08/08

MF 08-08-07

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Qty -043	Qty -045	Part Number	Description
X					D412-704-011	COPilot's EMERGENCY CARGO RELEASE KIT (210/212/214/412)
	X				D205-704-013	COPilot's EMERGENCY CARGO RELEASE KIT (205)
1	1	X			D412-704-041	PEDAL ASSEMBLY (205/210/212/214/412)
	1		X		D205-704-043	CABLE ASSEMBLY (205)
1				X	D412-704-045	CABLE ASSEMBLY (210/212/214/412)
					D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
					D3205-1	PEDAL BRACKET (OR ECM 999703-1)
					D3205-3	BACK PLATE (OR ECM 999709-5)
					D3206-1	PEDAL ARM (OR ECM 999704-1)
				1	D3207-1	BRACKET
1					D3207-2	BRACKET
	1				D3207-3	BRACKET
1					D3207-5	BRACKET
1	1				D3208-1	DOUBLER (OR ECM 999709-1)
1					D3208-11	FILLER
1	1				D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1				D3208-5	MOUNT ANGLE
1	1				D3208-7	FILLER (OR ECM 999709-3)
1					D3208-9	DOUBLER
				1	D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1				D3214-1	PLACARD (OR ECM 999712-1)
				1	D3217-1	CABLE
				1	D3217-3	CABLE
				1	D3257-1	FITTING
				1	D3258-1	ANGLE BRACKET
					AN315-4R	NUT
	5	2	2		AN960JD10	WASHER
	4	2	2		AN960JD10L	WASHER
	11				AN960JD416	WASHER
	3				AN960JD416L	WASHER
				3	NAS509-3	NUT
				3	MS21042L3	NUT (OR MS21042-3)
				5	MS21042L4	NUT (OR MS21042-4)
4	4				MS21919DG5	CLAMP
				1	MS24694-S102	SCREW
	2				MS35489-10	GROMMET
				1	AN3-5A	BOLT
				2	AN3-6A	BOLT
				1	AN3-10A	BOLT
				1	AN3-13A	BOLT
					MS9519-10	BOLT
					AN4-10A	BOLT
				2	AN4-12A	BOLT
				1	AN4-13A	BOLT

SHOP COPY

RETURN TO

ENGINEERING

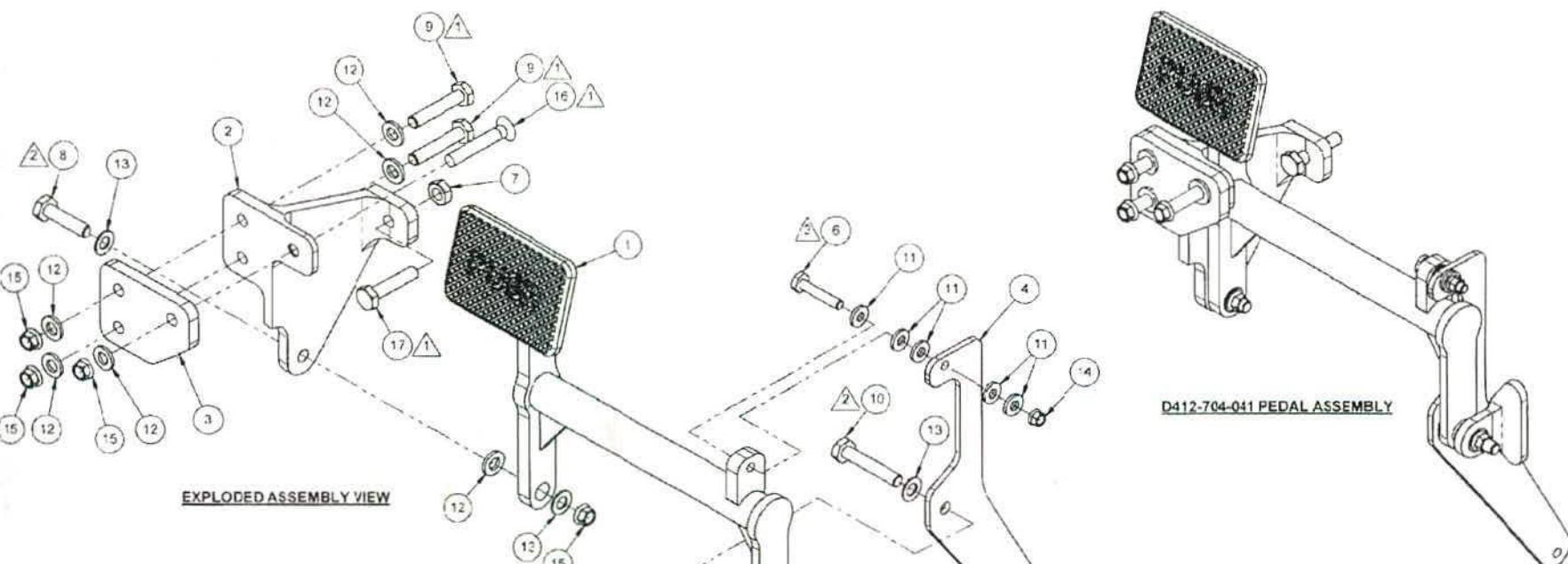
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 38858



EXPLODED ASSEMBLY VIEW

D412-704-041 PEDAL ASSEMBLY

PARTS LIST:

ITEM	QTY	P/N	DESCRIPTION
-	X	D412-704-041	PEDAL ASSEMBLY
1	1	D3204-041	PEDAL WELDMENT
2	1	D3205-1	PEDAL BRACKET
3	1	D3205-3	BACK PLATE
4	1	D3206-1	PEDAL ARM
5	1	D3209-041	BRACKET ASSEMBLY
6	1	AN3-10A	BCLT
7	1	AN315-4R	NLT
8	1	AN4-1CA	BCLT
9	2	AN4-12A	BCLT
10	1	AN4-13A	BCLT
11	5	AN960JD10	WASHER
12	11	AN960JD416	WASHER
13	3	AN960JD416L	WASHER
14	1	MS21042L3	NLT (OR MS21042-3)
15	5	MS21042L4	NLT (OR MS21042-4)
16	1	MS24694-S102	SCREW
17	1	MS9519-10	BOLT
N/A*	2	AN3-6A	BOLT
N/A*	4	AN960JD10L	WASHER
N/A*	2	MS21042L3	NLT (OR MS21042-3)

* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

NOTES:

- 1) INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
- 2) TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
- 3) TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).

A	07.01.23	NEW ISSUE	DESCRIPTION
REV.	DATE	DESIGNER	DRAWN BY
CB	CB		DART AEROSPACE LTD
CHEKED	APPROVED		HAWKESBURY, ONTARIO, CANADA
CE	MM		DRAWING NO.
			D412-704-041
DATE		TITLE	REV. A
07.01.23		PEDAL ASSEMBLY	SHEET 1 OF 1
			1.2

COPYRIGHT © 2007 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE USED OR COPIED EXCEPT IN THE EXPRESS CONDITION THAT IT WILL NOT BE SHOWN TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.